

Date: Thursday, 04/06/2009 9:02:59 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP WELDMENT
Job Number :	48377		
Estimate Number :	12577		
P.O. Number :		Part Number :	D3562042
This Issue :	04/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3562 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	47208	Drawing Revision :	E
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	11/06/2009
Written By :		Qty:	1
Checked & Approved By :	<i>MF 09-06-04</i>	Um:	Each
Comment :	Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD Est Rev:C ECN1048 07-12-18 DD verified by: EC Est Rev:D 08-07-28 add chemical conversion coat DD verified by:EC Est Rev:E 09-02-27 (seq13) QC9 to QC10 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>346910</i>

Check Material for any Dents or Defects

MF 09-06-04 1

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

MF 09-06-04 1

MF 09-06-04 1

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

50106104 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/06/2009 9:02:59 AM
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 48377

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PK 09.06.05 1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAN 09-06-08 ①

6.0

D3560042

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch: *347864*

PK 09.06.10 1

7.0

D3560044

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch: *346403*

PK 09.06.10 1

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Blind Rivet

batch: *M111477*

PK 09.06.10 1

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: *M109900*

PK 09.06.10 1
PK 09.06.10 1
PK 09.06.10 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 48377

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1050611 @

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

343535

09-06-12 1
09-06-11

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M110130

2-Grind end cap welds flush as per Dwg D3562

09-06-12 1
09-06-11
09-06-12 1

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09/06/12 (H)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/12 (H)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09-06-12

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:30AM

OVEN TEMPERATURE:

320F

09/11

09-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: STEP WELDMENT

Job Number: 48377

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

10:00 AM

41

09-06-12 (4)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: 1711013

BR 09-06-15 (1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PR 09/06/15 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SS 09/06/15 (4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/15 (4)

Job Completion



u 09.06.15

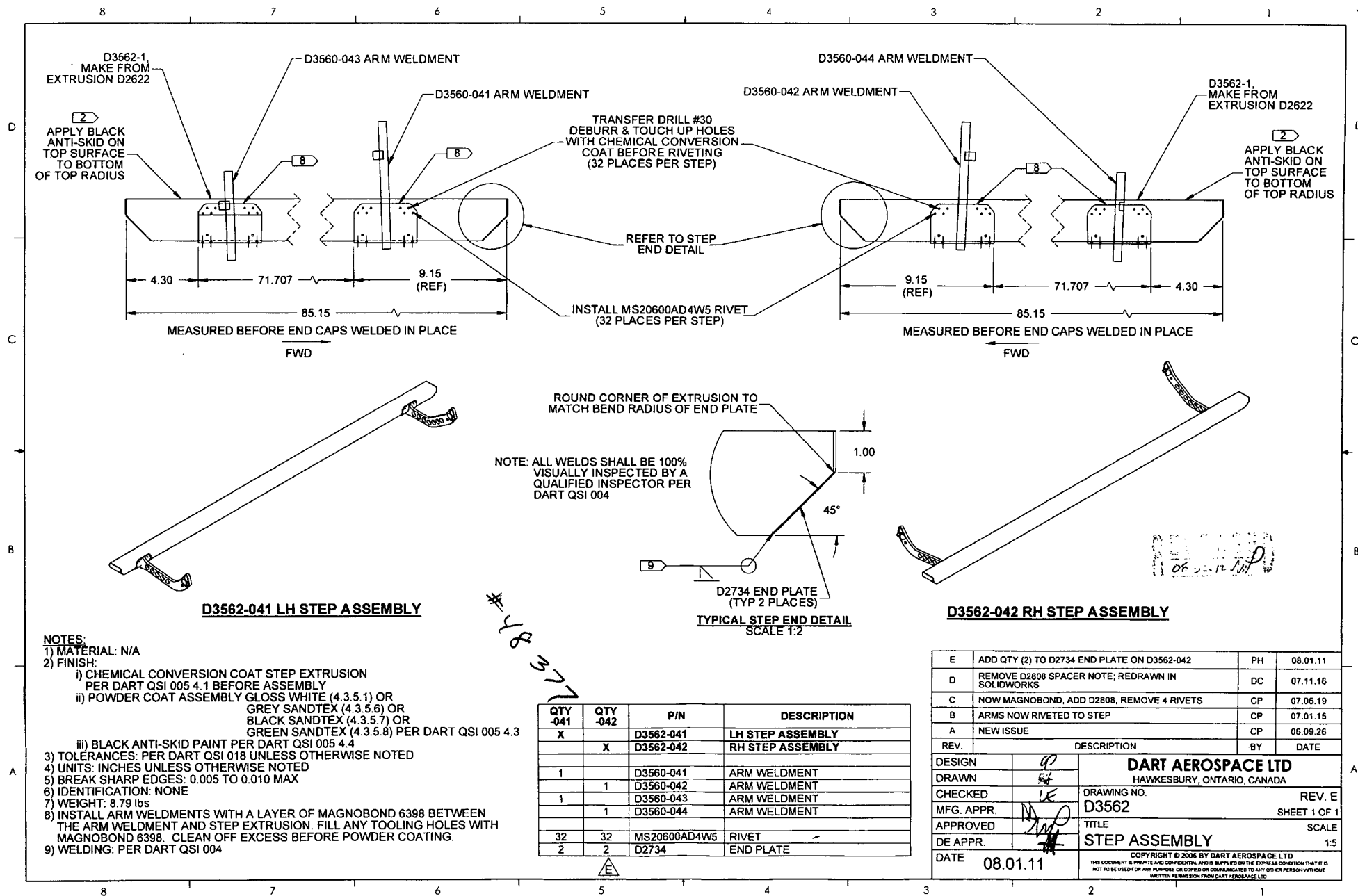
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NOTE: Date & initial all entries



E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	sf		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	MA	D3562	SHEET 1 OF 1
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	STEP ASSEMBLY	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	